

Work Order ID 129232

Friday, January 30, 2015 11:09:33 AM

129232

Page 1

Item ID: D4635-142 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd Ceiling Replacement Panel Assembly, RH
 Start Date: 1/30/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/30/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 1-30-15 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4635	DA6 27					DA6 27			
100		0.00							
100									
Hand Thermo	Memo	0.00							
Hand Finishing Thermoforming	Pick Kit								

FEB 05 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 25%;">Skid-tube ☐</td> <td style="width: 25%;">Crosstube ☐</td> <td style="width: 25%;">Water Jet ☐</td> <td style="width: 25%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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110

110

Small Fab

Small Fab

Memo

Assemble as per Dwg D4635-142
 Bond foam core to inside of panel
 3M Scotch Weld 1300 Batch: 130570

1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe

2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8)

Batch # 130298

Expiry Date 3/17/2015

3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9)

Batch: 124728

120

120

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

~~046~~
 27
~~0-30~~
 FEB 05 2015

15/02/05

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FAULT CATEGORY

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130	Identify as per dwg & Stock Location: <u>mt</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

D46
27
15/2/15

MLT 1502-06

15-2-5

DQA: _____ Date: _____



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FAULT CATEGORY

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Picklist Print

Friday, January 30, 2015 11:09:36 AM

Page 1

Work Order ID: 129232

129232

Parent Item: D4635-142

D4635-142

Parent Item Name: Fwd Ceiling Replacement Panel Assembly, RH

Start Date: 1/30/2015

Required Date: 1/30/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: Ipp Rev A New Issue 13/02/04 DL
Dwg. Update 12/11/08 DL
13/07/09 DL verf:DD
13/12/23 DL

IPP Rev B
IPP Rev. C Dwg Update
IPP Rev D Dwg Update Add Foam

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4635-2		Manufactured	No			100	Each	0.0000	1	1		27 27 FEB 05 2015	
D4635-2 Fwd Ceiling Panel, RH									**				
D4669-1		Manufactured	No			100	Each	57.0000	2	2		27 27 FEB 05 2015	
D4669-1 Bracket									**				
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				MF			57						
				124100			17						
				125017			40						
D4695-042		Manufactured	No			100	Each	4.0000	1	1		27 27 FEB 05 2015	
D4695-042 Channel Assembly, RH									**				
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				MF			4						
				125012			4						
D4732-3		Manufactured	No			100	Each	15.0000	1	1		27 27 FEB 05 2015	
D4732-3 Label									**				
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				MF			15						
				111254			8						
				120061			7						

DQA: _____ Date: _____



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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 2

Work Order ID: 129232

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Parent Item: D4635-142

D4635-142

Parent Item Name: Fwd Ceiling Replacement Panel Assembly, RH

Start Date: 1/30/2015

Required Date: 1/30/2015

Start Qty: 1.00

Required Qty: 1.00

D4732-31 Manufactured No

100 Each 16.0000 1 1

D4732-31

Label

DAS
27
9-29

Location

Loc Qty

Loc Code

MF

16

120076

4

123215

12

FEB 05 2015

D4732-35 Manufactured No

100 Each 16.0000 1 1

D4732-35

Label

DAS
27
9-29

Location

Loc Qty

Loc Code

MF

16

120078

4

123217

12

FEB 05 2015

D4732-7 Manufactured No

100 Each 15.0000 1 1

D4732-7

Label

DAS
27
9-29

Location

Loc Qty

Loc Code

MF4

15

120064

3

123203

12

FEB 05 2015

D5022-1 Manufactured No

100 Each 22.0000 1 1

D5022-1

Foam, Side Panel, Fwd

DAS
27
9-29
FEB 05 2015

Location

Loc Qty

Loc Code

MF

22

123925

11

126184

11

Friday, January 30, 2015 11:09:36 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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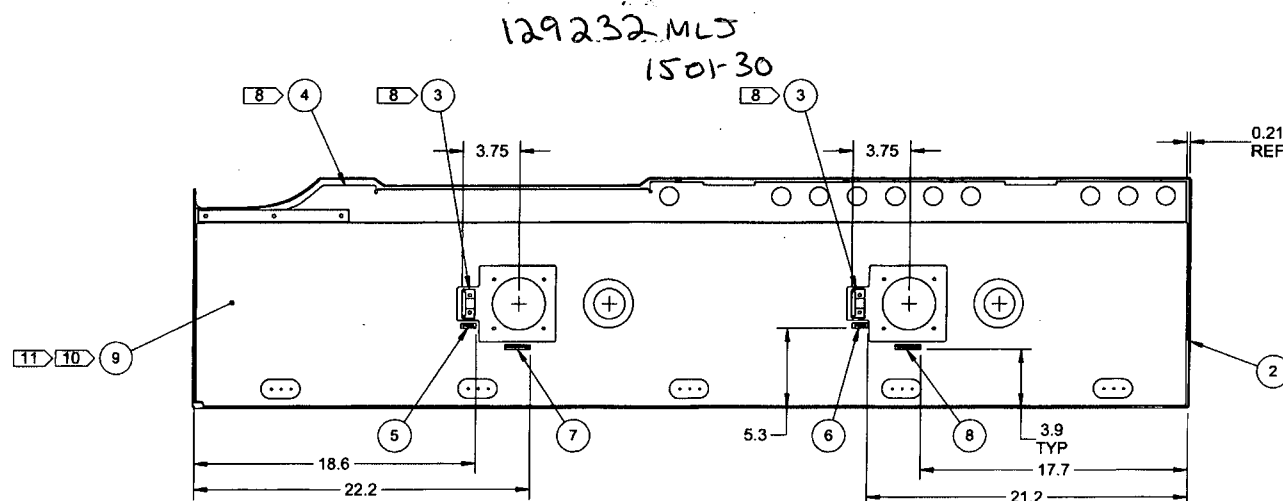
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ITEM	QTY -142	P/N	DESCRIPTION
1	X	D4635-142	RH, FWD CEILING REPLACEMENT PANEL ASSY
2	1	D4635-2	RH, FWD CEILING PANEL
3	2	D4669-1	BRACKET
4	1	D4695-042	RH CHANNEL ASSEMBLY
5	1	D4732-3	LABEL
6	1	D4732-7	LABEL
7	1	D4732-31	LABEL
8	1	D4732-35	LABEL
9	1	D5022-1	FOAM, SIDE PANEL, FWD



D4635-142 RH, FWD CEILING REPLACEMENT PANEL ASSY

RELEASED

2015 JAN 26 *up*

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) APPLY A BEAD (0.20 TO 0.30 WIDE) OF DEVCON PLASTIC WELDER II (0.25 INSIDE OF BOTH EDGES OF PART) TO BOND D4669-1 & D4695-042. WAIT FOR 2 TO 4 HOURS FOR FUNCTIONAL CURE
- 9) LOCATE LABELS AS SHOWN, SEAL LABELS USING 3950 EDGE SEALER OVER LABEL TOP SURFACE
- 10) APPLY AN EVEN COAT OF 3M SCOTCH WELD 1300L CONTACT ADHESIVE TO BOND D5022-1 FOAM CORE TO INSIDE OF PANEL
- 11) CENTER D5022-1 FOAM ON D4635-2

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AK	DRAWING NO.	REV. F
MFG. APPR.	DL	D4635	SHEET 10 OF 18
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	OUTBOARD CEILING PANELS	NTS
DATE	14.11.28	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			